

Split
Work Order ID 83138-2

Friday, April 13, 2012 10:10:37 AM

83138

Page 1

Item ID: D4005-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Floor Gutter

Start Date: 4/13/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

Date: 12-04-13 Tooling:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D4005

B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4005-13)

Dwg Rev:

Prog Rev:

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B17-5-20

B17-5-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83138

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Page 2

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Item Name: Fwd Floor Gutter

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Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 5.00 *5*

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12-05-30

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

Bend D4005-13 as per Dwg

①

Subtotal

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

576606

②

W/O:		WORK ORDER CHANGES					
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Stop *NS2*

Customer:

Stop *NR2*

0.00

Quality Control

Siributob

④

1 ~~0~~ BE 12/04/06

W/O:		WORK ORDER CHANGES					
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N9000040100

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Stop ***NS2***

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Start Date: 4/13/2012 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

1 7/6 12-6-7

155

QC 7-Inspect Chemical Conversion Coat

0.00

155

QC

Memo

0.00

Quality Control

Subtotal

(K)

160

Gloss Grey (4.3.5.15) per QSI 005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

Start Time: 11h15
Oven Temperature: 320°F
Finish Time: 11h45

1 x (SP) 12/06/08.

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

170

QC3-Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location **143**

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

Per 4/8 (1)

Per 4/8 (1)

12/6/11 DJ

ME 12-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, April 13, 2012 10:10:41 AM

Page 1

Work Order ID: 83138

83138

Parent Item: D4005-041

D4005-041

Parent Item Name: Fwd Floor Gutter

Start Date: 4/13/2012

Required Date: 4/25/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A 10.01.21 new issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC IPP Rev:C 12.03.07 as
per dwg rev.b DD verif: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	352.5700	0.42	2.210526	3		

M6061T6S 040

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

352.57

121030

82.07

121099

270.5

D4003-13

Manufactured No

141 Each

8.0000

1

5

D4003-13

Fwd Fael Gutter Line

**

Location

Loc Qty

Loc Code

WA

8

78374

8

1

8
12.06.06

W/O:		WORK ORDER CHANGES					
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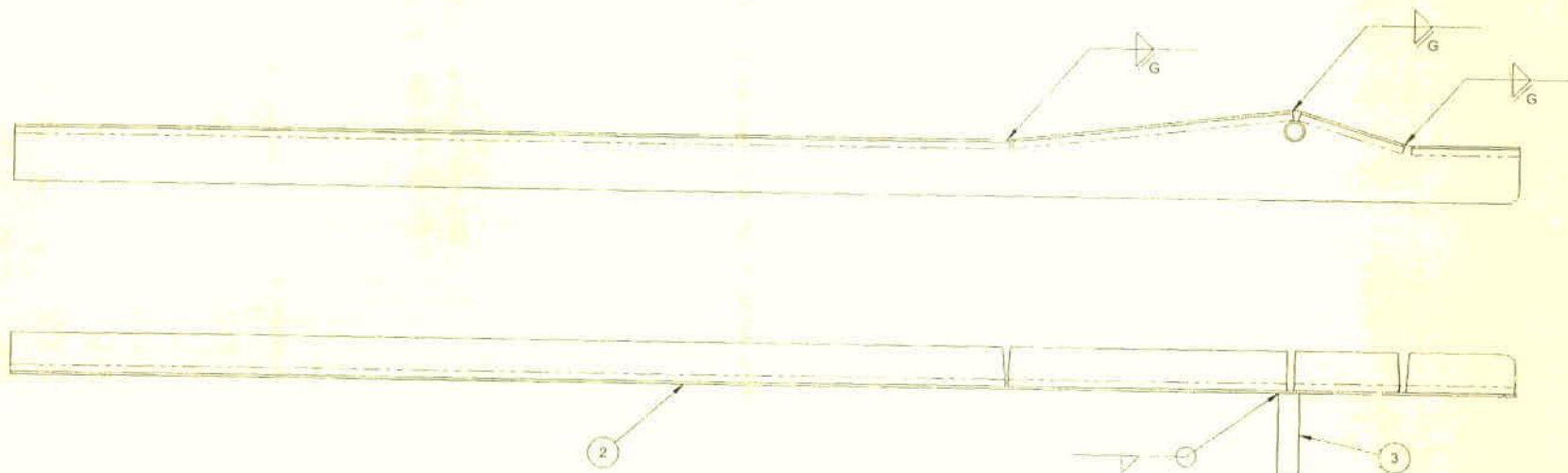
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4005-041	FORWARD FLOOR GUTTER	JCA-M47-2-22
2	1	D4005-13	ANGLE	
3	1	D4003-13	TUBE	



D4005-041 FORWARD FLOOR GUTTER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.22 lbs
- 8) WELD PER DART QSI 004

B	ADD TOOLING HOLE, ZN C7-3	HS	11.06.06
A	NEW ISSUE	HS	10.02.05
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR			
APPROVED			
DE APPR			
DATE	11.06.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4005
TITLE RESTRAINT
REV. B
SHEET 1 OF 15
SCALE NTS

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RELEASED
2012-03-02
JMP

83138

12-04-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

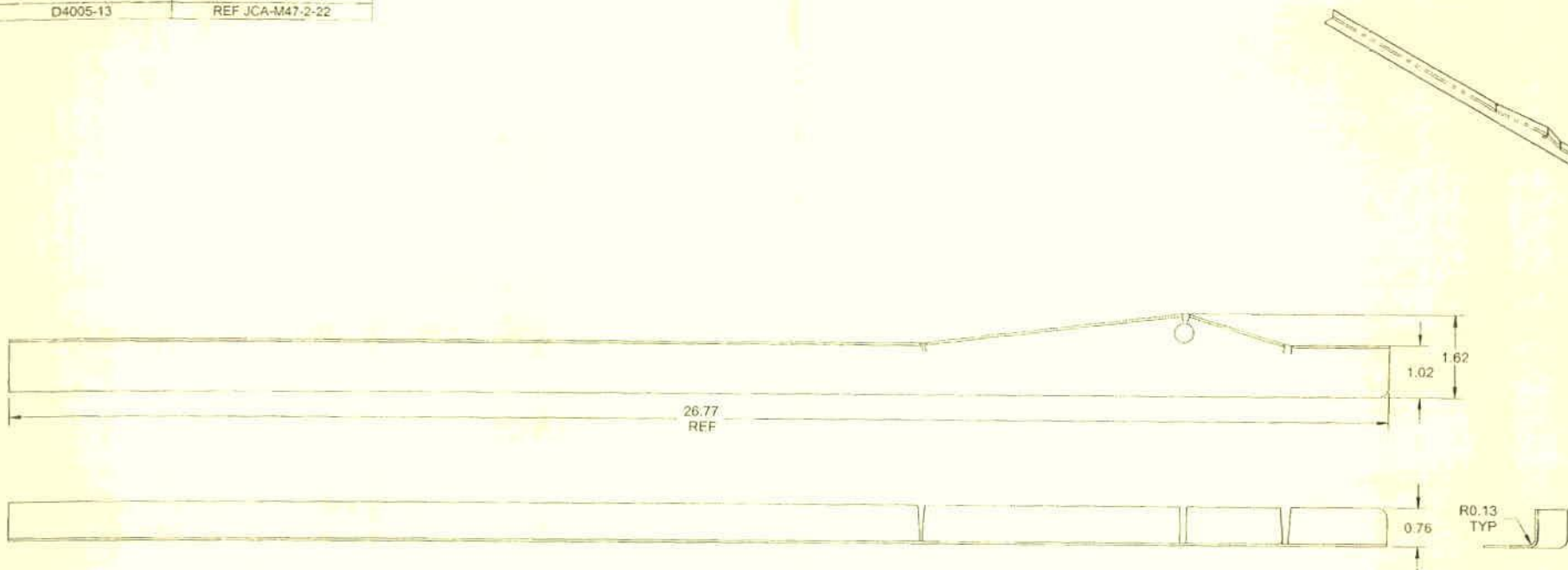
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE
PART NUMBER
D4005-13

JOHN CAMERON AVIATION
PART NUMBER
REF JCA-M47-2-22



D4005-13 ANGLE

8313d

RELEASED
JUN 2012-03-02
JHP

- NOTES:
- 1) MATERIAL: MADE FROM D4005-13F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.21 lbs

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO.	REV. B
MFG. APPR.	DE	D4005	SHEET 14 OF 15
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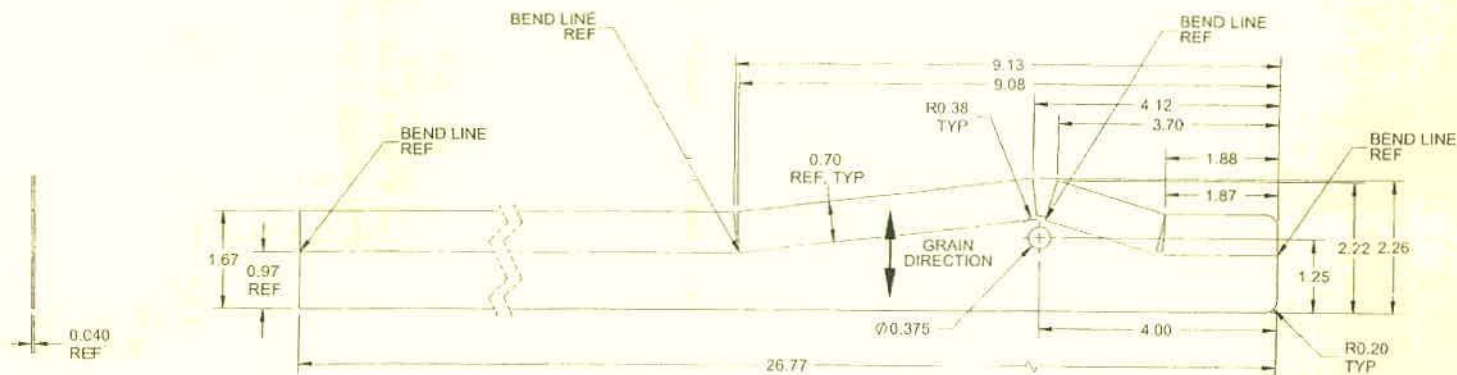
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D4005-13F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV B
MFG. APPR.		D4005	SHEET 15 OF 15
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2012-03-02

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